

Work Order ID 51255

August 13, 2009 6:56:44 AM



Page 1

Item ID: D3405-043

Accept



Setup Start



Revision ID: B

Stop



Item Name: Lug Assembly

Start Date: 08/13/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 08/28/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: mf Date: 09-08-13 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
----------	--------------

D3405	Rev B
-------	-------

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3405 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

⑫
mf

09 08 19

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

mf

09 08 19

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

=> 8 09/08/19

⑫
f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51255

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Page 2

Item ID: D3405-043	Accept		Setup	Start	
Revision ID: B				Stop	
Item Name: Lug Assembly					
Start Date: 08/13/2009	Start Qty: 12.00		Cust Item ID:		
Required Date: 08/28/2009	Req'd Qty: 12.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00							
Brake NC	Memo	0.00	SB	09/08/20		82	0		
Brake NC	Deburr Form using DT8204 as per Dwg D3405								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00	2)	8 02/04/20		12	0		
Quality Control									
150 	Large Fab	0.00							
Large Fab	Memo	0.00	EL	9-8-24		12			
Large Fab	Weld as per Dwg D3405 Identify as D3405-043								

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Page 3

Item ID: D3405-043

Accept



Setup Start



Revision ID: B

Stop



Item Name: Lug Assembly

Start Date: 08/13/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 08/28/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

6/6/09.05.24

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 502/08/24

(12)

0

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

11/11/2260

0.00

Powder Coating

=> 9/09/08/25

12

0

START TIME: *7:00am* OVEN TEMPERATURE:
7:30am FINISH TIME: *9:00pm*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



Work Order ID 51255




August 13, 2009 6:56:44 AM



Page 4

Item ID: D3405-043 Accept  Setup Start 
Revision ID: B Stop 
Item Name: Lug Assembly
Start Date: 08/13/2009 Start Qty: 12.00  Cust Item ID:
Required Date: 08/28/2009 Req'd Qty: 12.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	<i>BK</i>	<i>09-08-25</i>			<i>(12)</i>		
200  Packaging Packaging	Identify as per dwg & Stock Location: <i>474</i> Memo	0.00 0.00					<i>9/8/26</i>	<i>(12x) SP</i>	
210  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00					<i>09/08/26</i>	<i>HJ</i>	

BK 09-8-26 (12)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

August 13, 2009 6:56:44 AM

Page 1

Work Order ID: 51255

Parent Item: D3405-043RevB

Parent Item Name: Lug Assembly

Comments:

Start Date: 08/13/2009

Required Date: 08/28/2009

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3404-1RevC		Manufactured	No			100	Each	8.0000	12.0000			

GHW Lug

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST 60471

8

150

sf

79.0709

1.9453

EL 9-8-24

M304S11GA

Purchased

No

304/316 0.125 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

111018

79.07090316

79.0709032

m/ 09-08-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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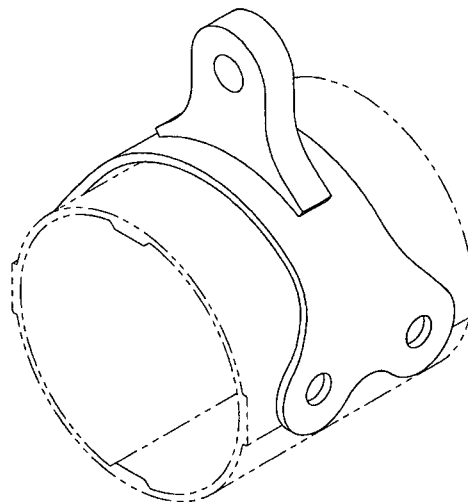
NOTE: Date & initial all entries

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

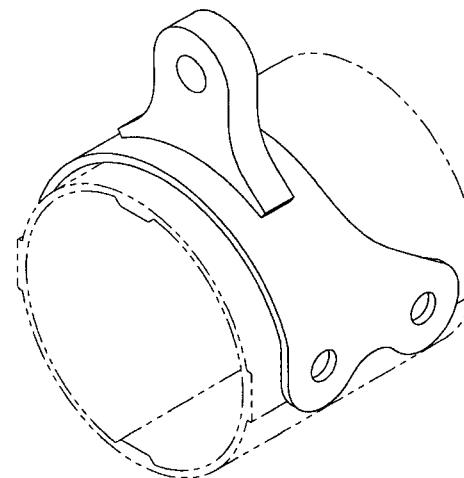
△B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51255

mf 09-08-13



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

RELEASED
08/12/18 M/P

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.	AJS	08.09.19
A	NEW ISSUE	PH	05.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3405	REV. B
MFG. APPR.			SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

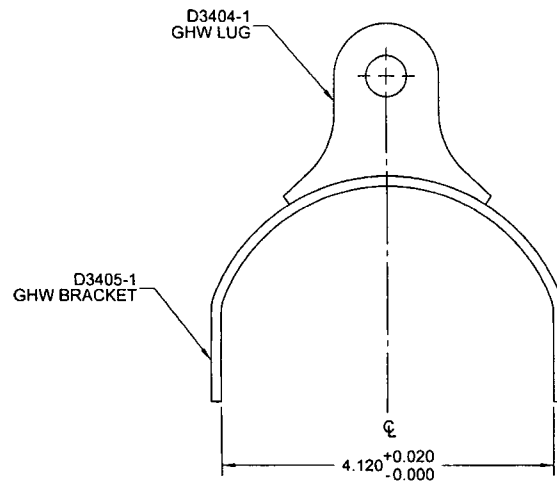
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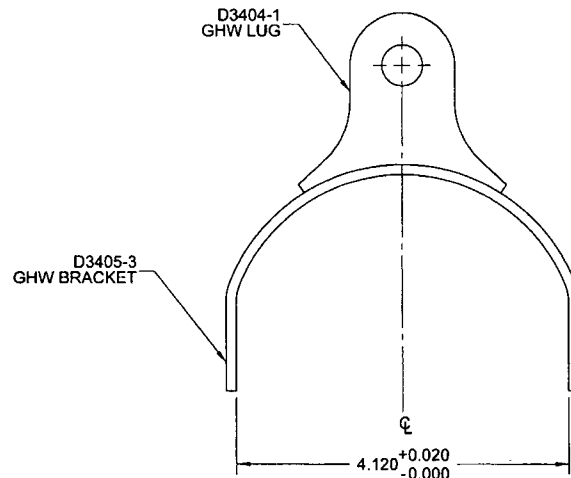
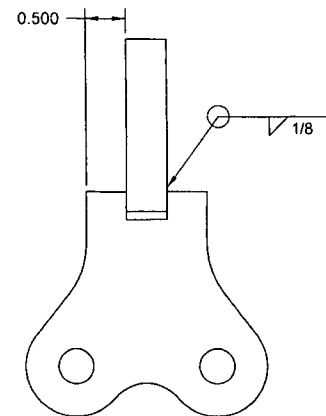
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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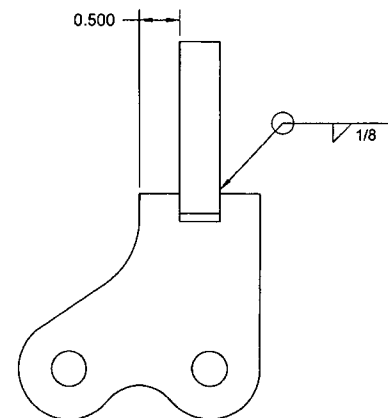
NOTE: Date & initial all entries



D3405-041 LUG ASSEMBLY



D3405-043 LUG ASSEMBLY



51255

RELEASED
06/12/18 MJP

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 2 OF 4
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Dart Aerospace Ltd

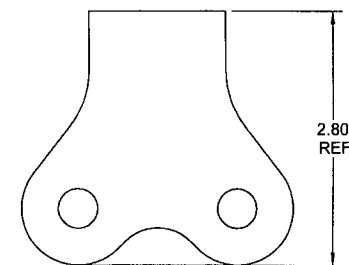
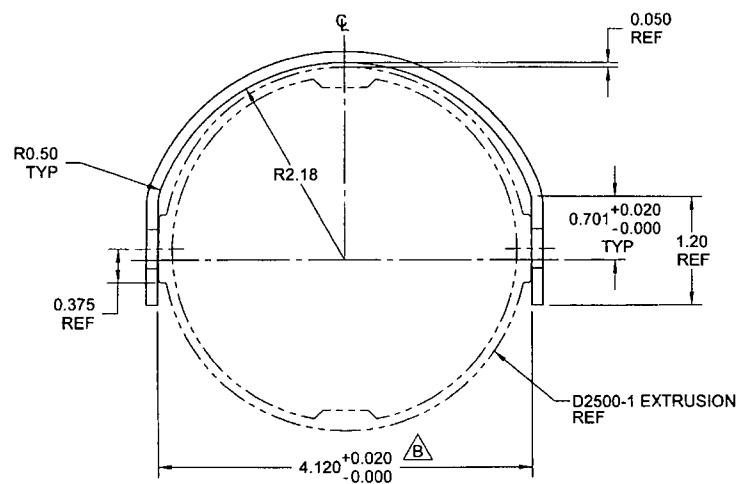
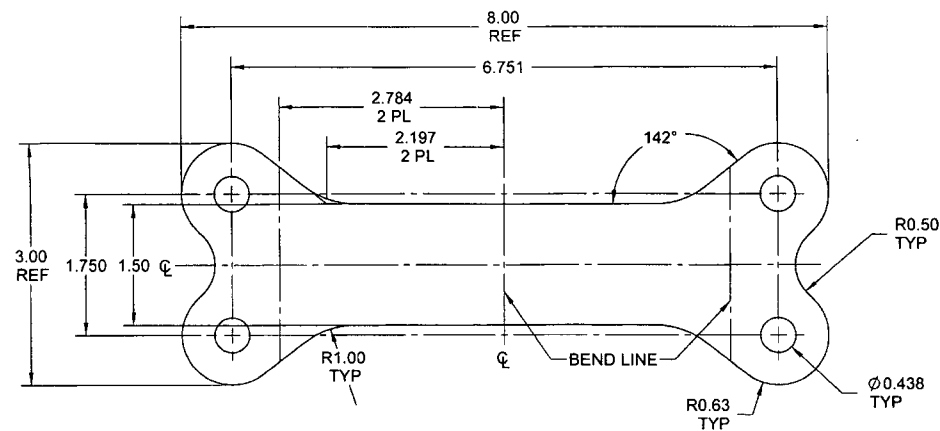
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



51255

RELEASED
MP-08/12/16

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. PART SPEC. M304S11GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QCI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3405	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GHW LUG ASSEMBLY	NTS
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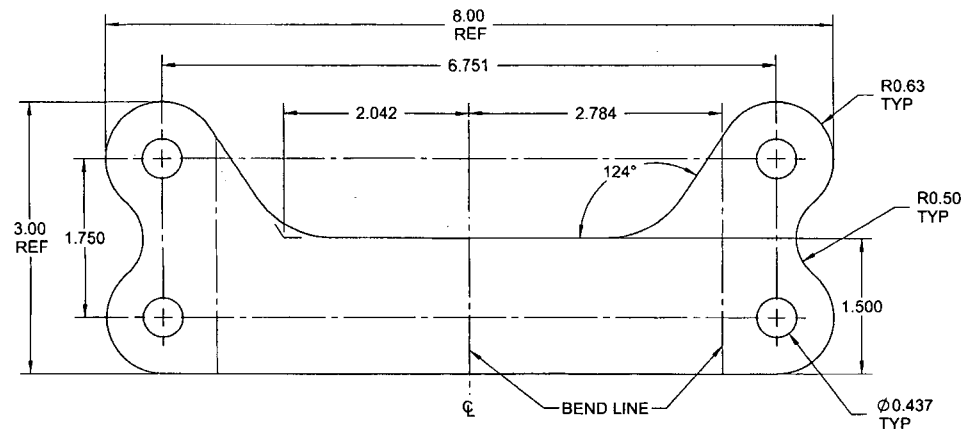
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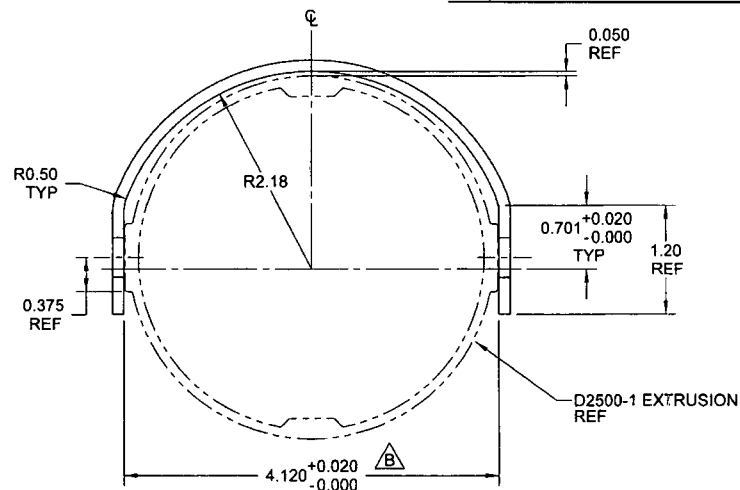
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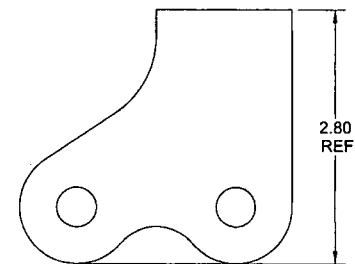
NOTE: Date & initial all entries



D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 4 OF 4
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51255

RELEASED
06/12/18 NV

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